

Work Order ID 64763

Thursday, December 16, 2010 11:43:26 AM

Page 1

Item ID: D3578-041

Accept

Setup Start

Revision ID:

Item Name: Doubler

Stop

Start Date: 12/16/2010 Start Qty: 40.00

Required Date: 12/21/2010 Req'd Qty: 40.00

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3578

Rev A

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3578 (Run prog. D3578-1)

Dwg Rev: A

Prog Rev: A

2-Deburr if necessary

1210-12-16

45

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

1210-12-16

120

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

80012/17

count

45

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Item ID: D3578-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Doubler

Start Date: 12/16/2010 Start Qty: 40.00



Cust Item ID:

Required Date: 12/21/2010 Req'd Qty: 40.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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130

0.00



Small Fab

Small Fab

Memo

0.00

Small Fab

1-Open rivet holes to 0.098" and C'sink as per dwg D3578

Handwritten signature and date 10/12/20 with circled 45

140

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

Handwritten date 10/12/20

Handwritten signature and circled 45

150

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

Handwritten date 10/12/20

Handwritten signature and circled 45

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Start Date: 12/16/2010 Start Qty: 40.00

Required Date: 12/21/2010 Req'd Qty: 40.00

Reference:

Cust Item ID:

Customer:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

45 Br 10-12-00

170

Small Fab

0.00



Small Fab

Memo

0.00

Small Fab

1-Assemble as per dwg D3578

E/S 10/01/04 (45)

180

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

S 11/01/04

10/01/04
(45)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Page 4

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Stop



Item Name: Doubler

Start Date: 12/16/2010 Start Qty: 40.00



Cust Item ID:

Required Date: 12/21/2010 Req'd Qty: 40.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

190

Identify as per dwg & Stock Location: 240A

0.00



Packaging

Memo

0.00

Packaging

11/01/04 (48)

200

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

CK 11/01/04
MF
~~10-12~~
11-01-04

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

Picklist Print

Thursday, December 16, 2010 11:43:30 AM

Page 1

Work Order ID: 64763

Parent Item: D3578-041

Parent Item Name: Doubler




Start Date: 12/16/2010

Required Date: 12/21/2010

Start Qty: 40.00

Required Qty: 40.00

Comments: IPP: A07.04.11 New issue EC
IPP RevB 10.10.21 remove D3569-1 DD verf:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MS20426AD3-3  Rivet		Purchased	No			110	Each	3,879.000	2	80		12/11/04	
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST316				3879					
					19099			3879		90			
M6061T6S.080  6061-T6 .080 Sheet		Purchased	No			170	sf	200.4000	0.007	0.294737		12-12-16	
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				MAT				200.4					
					116268			200.4					
MS21075L3  Nutplate		Purchased	No			170	Each	23.0000	1	40		12/11/04	
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST303				22					
					113734			1					
					116242			21		21			
				ST350				1					
					115908			1					

M116513 (24)

W/O:		WORK ORDER CHANGES					
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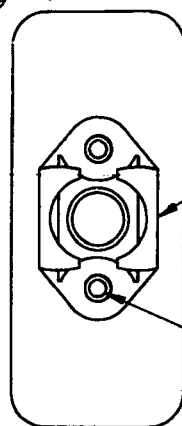
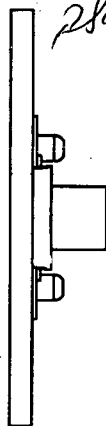
NOTE: Date & initial all entries



UNCONTROLLED COPY
SUBJECT TO AMENDMENT

WITHOUT NOTICE
WORK ORDER
NO. 641743

280-12-16



D3578-1 PLATE

MS21075L3 NUT PLATE

MS20426AD3-3 RIVET
(2 PLACES)

RELEASED
07.04.02

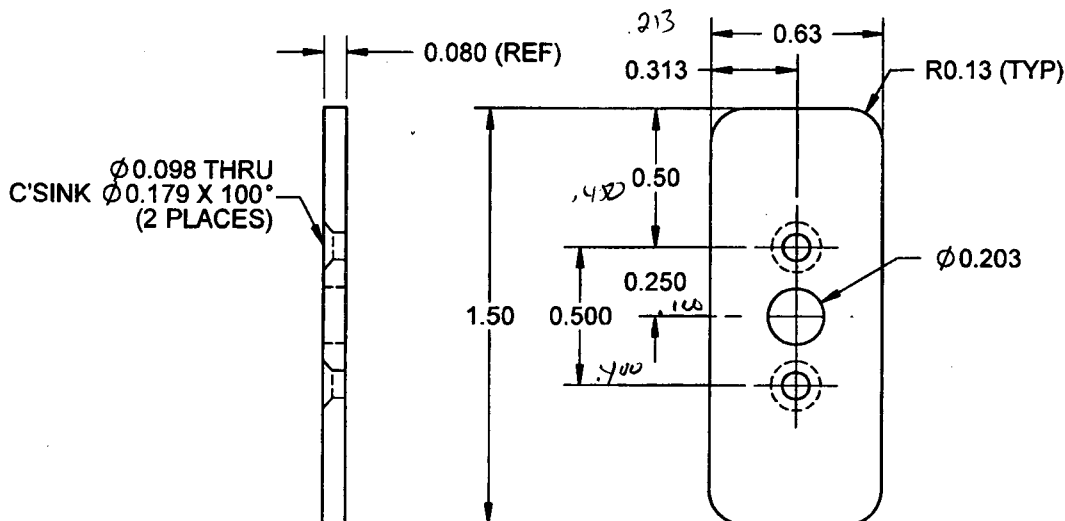
D3578-041 PARTS LIST:

QTY	P/N	DESCRIPTION
X	D3578-041	DOUBLER
1	D3578-1	PLATE
1	MS21075L3	NUT PLATE
2	MS20426AD3-3	RIVET

D3578-041 DOUBLER

D3578-041 NOTES:

1) IDENTIFY WITH DART P/N "D3578-041" USING FINE POINT PERMANENT INK MARKER



D3578-1 PLATE

D3578-1 NOTES:

- 1) MATERIAL: 6061-T6 (OR T62) ALUMINUM SHEET 0.080 THICK PER QQ-A-250/11 OR AMS 4025 OR 4027 (REF DART SPEC M6061T6S.080)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX

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